



① -17 AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY

SCALE 0.250

PREMIER AVIATION, INC.
2622 Aviation Parkway, Grand Prairie, Texas 75050
DIOSUVB B67-43001

ORIGINAL

WORK ORDER NO. 43608
SUBJECT TO AMENDMENT WITHOUT NOTICE
UNCONTROLLED COPY

SHOP COPY
RETURN TO ENGINEERING

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:45:08 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41368

Part Number: PB674300117

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Do 8/10/23 (72)

21.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *carl welding*

Sodis 8/23 (72)

22.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23 JJ

Job Completion



MF 08-10-23

W/O:		WORK ORDER CHANGES					
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Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

er: 41368

Part Number: PB674300117



Machine Or Operation:

Description :

START TIME:

9-00
OF

OVEN TEMPERATURE:

320
A-30

FINISH TIME:

(2X)
m-f 08/09/30

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION




08-09-30

(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

20 Degree Cover Plate

batch: B41513 x4

Cpl 08.10.22

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

PB67-43001-83

batch: B41516 x4

Cpl 08.10.22

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Screw

batch: M109031

Cpl 08.10.22

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

WASHER

batch: M109031

Cpl 08.10.22

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

Cpl 08.10.22

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

7.0 QC9



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 08.09.29

BE 08-09-29

8.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/09 (F2)

9.0 MS124780



HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

HELICAL INSERT

323434 17935

11 08.09.29

10.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only

11 08.09.29

- 2- install helicol insert as per dwg

11 08.09.29

11.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/09 (F2)

12.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

14 S 08/09/30

13.0 POWDER COATING



POWDER COATING



M 102316

(2X)

Comment: POWDER COATING

- 1- MASK TUBE FROM BASE TO GUSSET

- 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

m.f 08/09/30

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NOTE: Date & initial all entries

Monday, 18/08/2008 3:45:08 PM
Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT ADJUSTABLE BLADE SUPPORT ASSY		
Job Number	: 41368			Part Number	: PB674300117		
Estimate Number	: 13434			Drawing Number	: B6743001 P.7		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/08/2008	S.O. No.	:	Drawing Revision	: B1		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 18/09/2008		
Previous Run	: 40609			Qty:	8 Um: Each		
Written By	:			<i>Julie 2.</i>			
Checked & Approved By	: <u>DU088-18</u>						
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec						
Additional Product							
Job Number: 							
Seq. #:	Machine Or Operation:	Description :					
1.0	PB6743001259	Inner Tube 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Inner Tube batch: <u>413196</u> <i>M 08.09.26</i>							
2.0	PB6743001249	Inner Tube Bushing 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Inner Tube Bushing batch: <u>823434</u> <i>M 08.09.26</i>							
3.0	PB6743001253	Gusset 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Gusset batch: <u>4041141492</u> <i>M 08.09.26</i>							
4.0	PB6743001254	Gusset 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Gusset batch: <u>4045341493</u> <i>M 08.09.26</i>							
5.0	PB674300171	PB67-43001-71 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) PB67-43001-71 batch: <u>41812</u> <i>M 08.09.26</i>							